

Work Order ID 81457-2

Wednesday, March 14, 2012 11:01:25 AM

\*81457\*

Page 1

Item ID: D3912-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Eyebolt Receiver Assembly

Start Date: 3/14/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: *WMC*

Date: 12-03-14 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3912

B

100

Pick Kit

0.00

\*100\*

Packaging

Memo

0.00

Packaging

110

0.00

\*110\*

Small Fab

Memo

0.00

Small Fab

1-Assemble D3912-1/-3/-5 and install rivets as per dwg.  
TRIM RIVETS 1.250" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg.

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

*5/17/16*

*03x E*

*12/04/16*

*03x*

*12/04/16*

*(15)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/16	110	6 MS21209-F615 are scrap Tool is not good R.C process	J 12/04/16 as 7042	Scrap + destroy order new tool	J 12/04/16	J 12/04/16	J as 7047 12/04/16	J 12/04/16

NOTE: Date & initial all entries

# Work Order ID 81457

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Page 2

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Start Date: 3/14/2012 Start Qty: 6.00 **\*6\***

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Required Date: 3/30/2012 Req'd Qty: 6.00 **\*6\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

170

Identify as per dwg & Stock Location: **50A**

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

**30**

**12/4/16**

**ML 12/04/16**

**12-04-16**

# Picklist Print

Wednesday, March 14, 2012 11:01:24 AM

Page 1

Work Order ID: 81457

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B 10.06.10 memo in seq110 \*\*\*IF PLUNGER GOES IN TO DEEP, INSTALL A WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO FIT\*\*\* DD ver:JLM IPP REV:C AS PER REV B 10-08-05 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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NAS1149C0663R Washer		Purchased	No				Each	196.0000		6			
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Location	Loc Qty	Loc Code
ST297	196	
116893	196	

D3912-1 Eyebolt		Manufactured	No			100	Each	22.0000	1	6			
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Location	Loc Qty	Loc Code
FG091	-12	
69593	0	
ST070	21	
77073	12	
77552	9	
ST091	13	
69593	1	

D3912-3 Eyebolt Block		Manufactured	No			100	Each	10.0000	2	12			
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Location	Loc Qty	Loc Code
ST070	10	
77554	10	

D3912-5 Eyebolt Plate		Manufactured	No			100	Each	7.0000	2	12			
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Location	Loc Qty	Loc Code
ST070	7	
76961	7	

EPB12/04/16

EPB12/04/16

EPB12/04/16

B82040 (2)

EPB12/04/16

B82042 (4)

B81458 (2)



# Picklist Print

Wednesday, March 14, 2012 11:01:25 AM

Page 2

Work Order ID: 81457

Parent Item: D3912-041

Start Date: 3/14/2012

Required Date: 3/30/2012

Parent Item Name: Eyebolt Receiver Assembly

Start Qty: 6.00

Required Qty: 6.00

D3801-1 Manufactured No  
Hand Retractable Spring Plunger

Each 18.0000

6

Location	Loc Qty	Loc Code
GA	6	
80996	6	
ST064	12	
68379	2	
75178	10	

MS20615-4M20 Purchased No  
RIVET

100 Each 122.0000

8

48

Location	Loc Qty	Loc Code
FP	50	
120644	50	
GA	72	
119546	26	
119638	46	

MS21209-F615 Purchased No  
Heli-Coil.

Each 64.0000

6

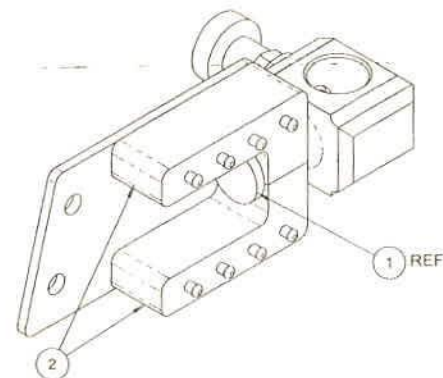
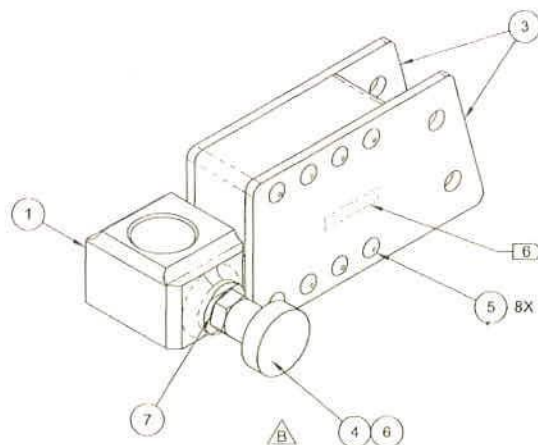
Location	Loc Qty	Loc Code
ST304	18	
108170	11	
108244	7	
ST305	46	
108170	0	
108244	0	
120072	46	

Wednesday, March 14, 2012 11:01:25 AM

Shop Packet Print

Page 2

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW  
(EYEBOLT PLATE REMOVED  
TO SHOW INTERIOR FEATURES)

# **D3912-041 EYEBOLT RECEIVER ASSY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041: 1.58 lbs

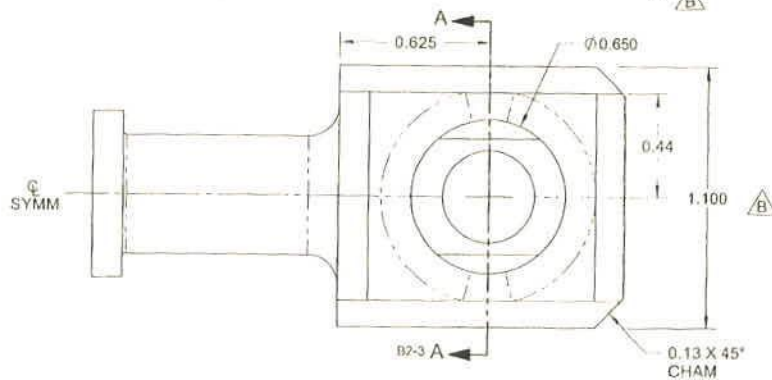
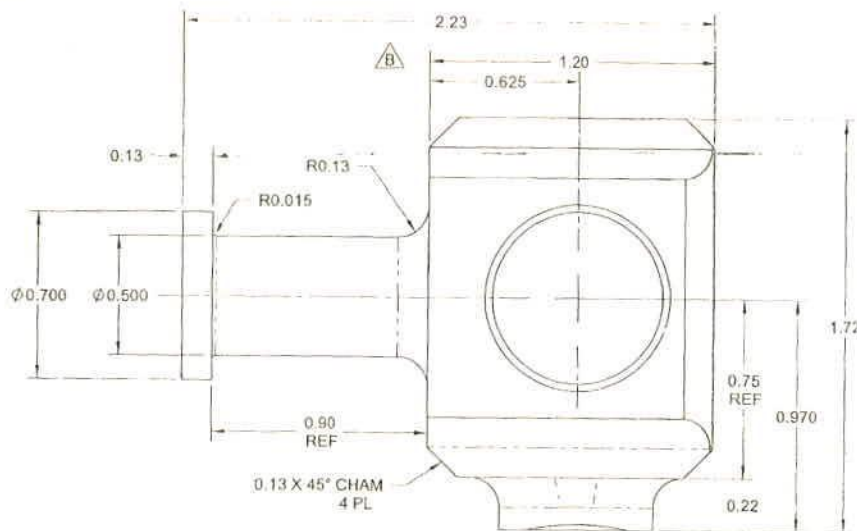
B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV. MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0683R ADDED, BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.06.28		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B  
SHEET 1 OF 3

TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

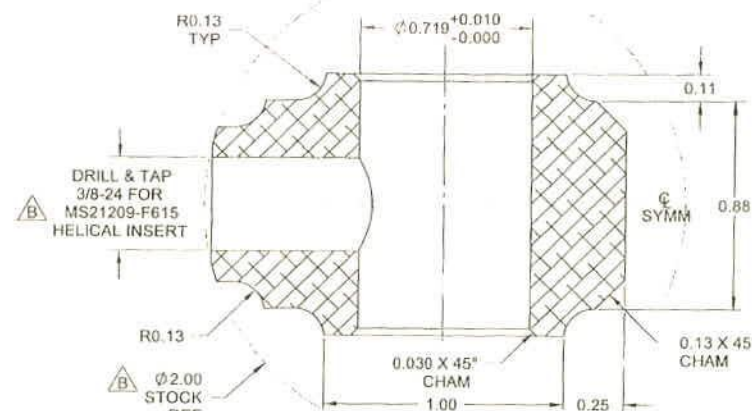
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**D3912-1 EYEBOLT**

**NOTES:**

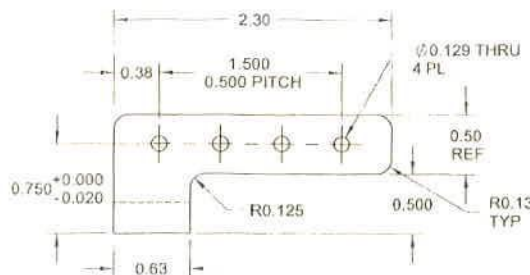
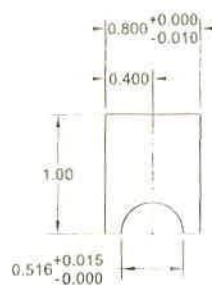
- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



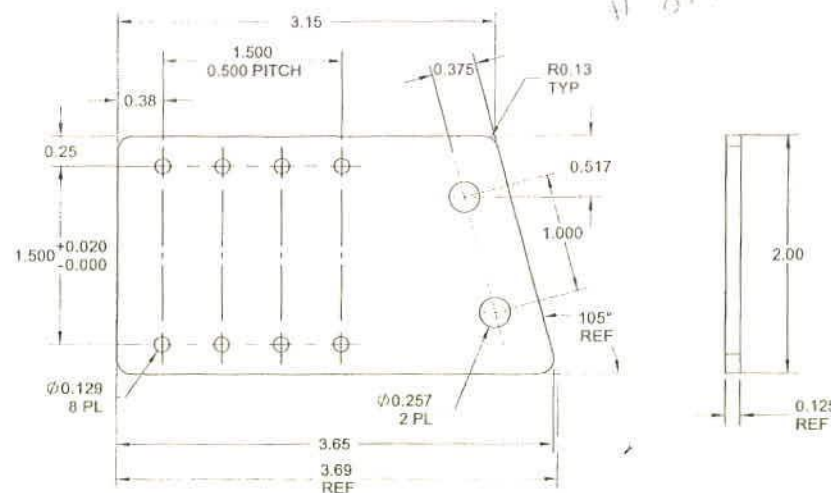
**SECTION A-A B6-3**

**RELEASED**  
2010-07-16

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	81	HAWKESBURY, ONTARIO, CANADA	
CHECKED	81	DRAWING NO. <b>D3912</b>	REV. B
MFG. APPR	81	TITLE	SHEET 2 OF 3
APPROVED	81	<b>EYEBOLT RECEIVER ASSY</b>	SCALE
DE APPR	81	COPYRIGHT © 2010 BY DART AEROSPACE LTD	NTS
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**D3912-3 EYEBOLT BLOCK**



**D3912-5 EYEBOLT PLATE**

**NOTES**

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240  
REF DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs  
-5: 0.24 lbs

**RELEASED**  
2010-07-16  
*md*

DESIGN	<i>A/S</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>A/S</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>A/S</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>A/S</i>	<b>D3912</b>	SHEET 3 OF 3
APPROVED	<i>A/S</i>	TITLE	SCALE
DE APPR.	<i>A/S</i>	<b>EYEBOLT RECEIVER ASSY</b>	NTS
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